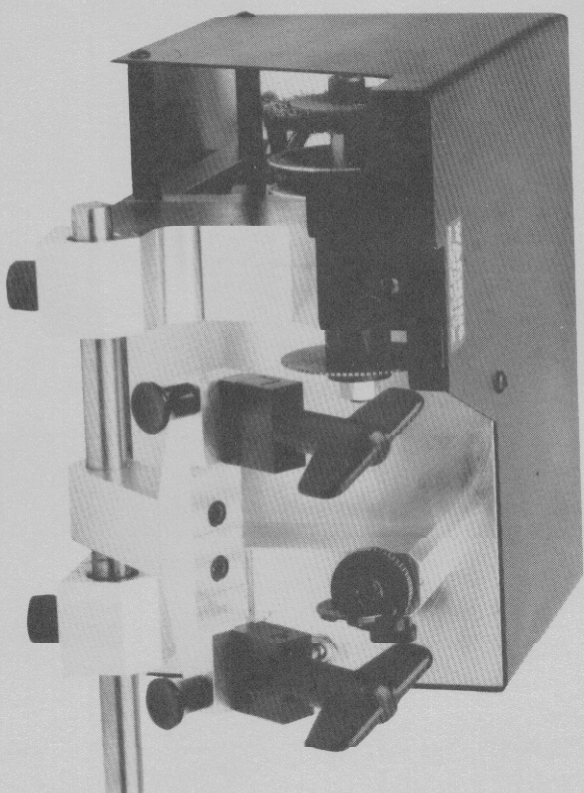


DBM-1

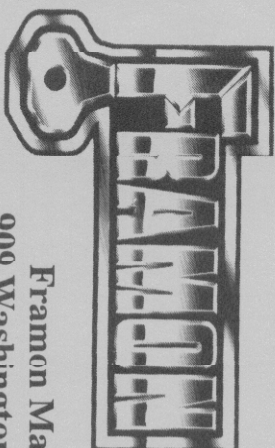
Flat Key Machine



**Instruction Manual
&
Parts Book**

**NEW AREA CODE
(989)**

(517) 354-5623



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CUTTING PROCEDURE FOR FRAMON

DBM-1 FLAT KEY MACHINE

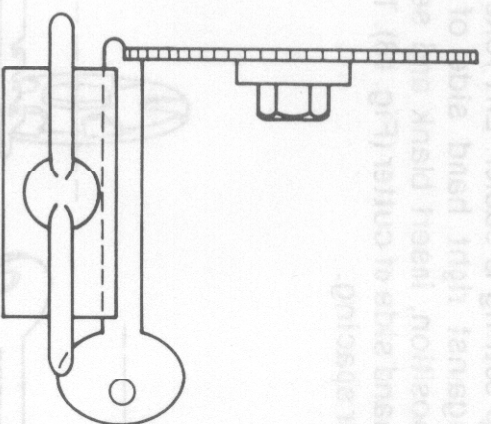


Figure 1

All keys should be set from the tip for spacing.

1. Insert pattern key in right hand vise with tip of blank protruding slightly beyond left hand vise (Fig #1). The reason for this position is to allow cutting of tip guide on blank if blank tip is slightly different than pattern key. In this position tip can be cut without cutting vise.

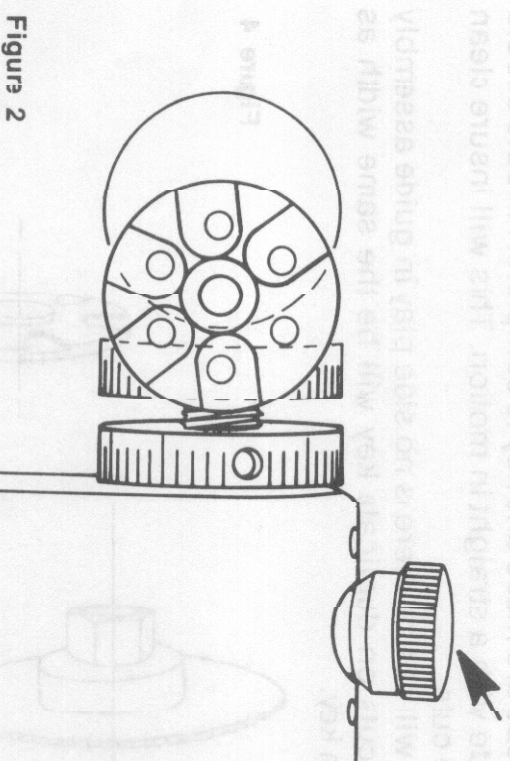


Figure 2

Push guide shaft rearward and lock into this position by tightening locking knob (Fig. #2). This relieves spring pressure so tip setting is easier. Lift yoke and set tip of pattern key against right hand side of guide. While holding this position, insert blank and set tip of blank against right hand side of cutter (Fig. #3). This procedure assures proper spacing.

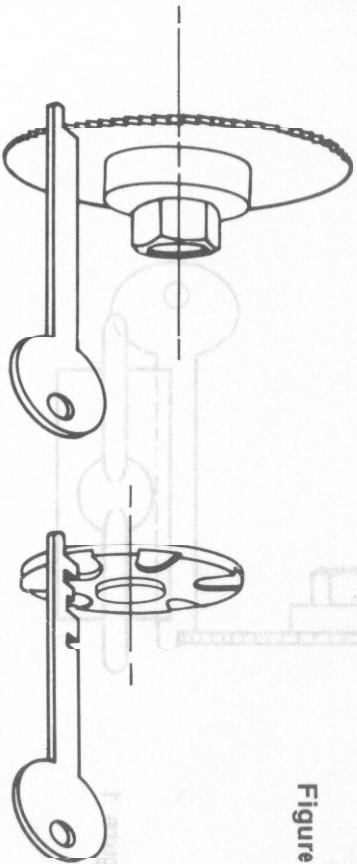


Figure 3

Release guide by loosening locking knob and key is ready to be cut.

Set cut in pattern key against guide and lift yoke into cutter to make cut (Fig. #4), lower yoke and repeat for next cut. Follow this procedure until all cuts (including throat cut) are made and key is complete. All cuts should be made with a straight ir motion. This will insure clean square cuts

You will notice there is no side play in guide assembly so all cuts on duplicate key will be the same width as pattern key.

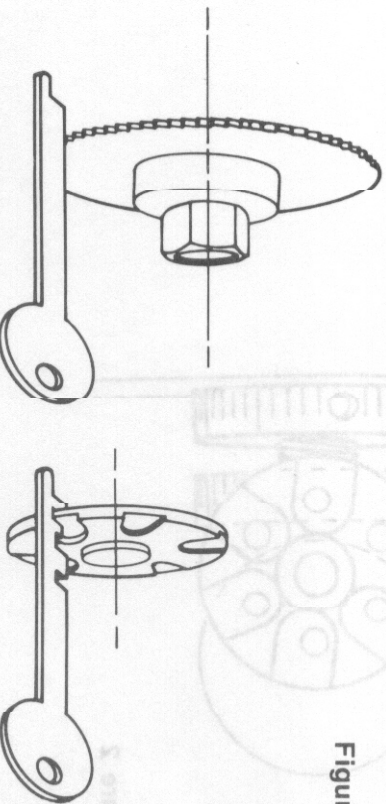


Figure 4

MAINTENANCE

Yoke rod (DCSH107), guide shaft (DBSH112) and vise studs (F2SC003) should be lubricated using very fine oil sparingly (do not use motor oil).

Be sure to wipe off all excess oil. To lubricate guide shaft (DBSH-112), unscrew locking knob (DBMS052) and put one or two drops of oil in opening and replace knob.

Other than these parts, cleanliness is the best maintenance.

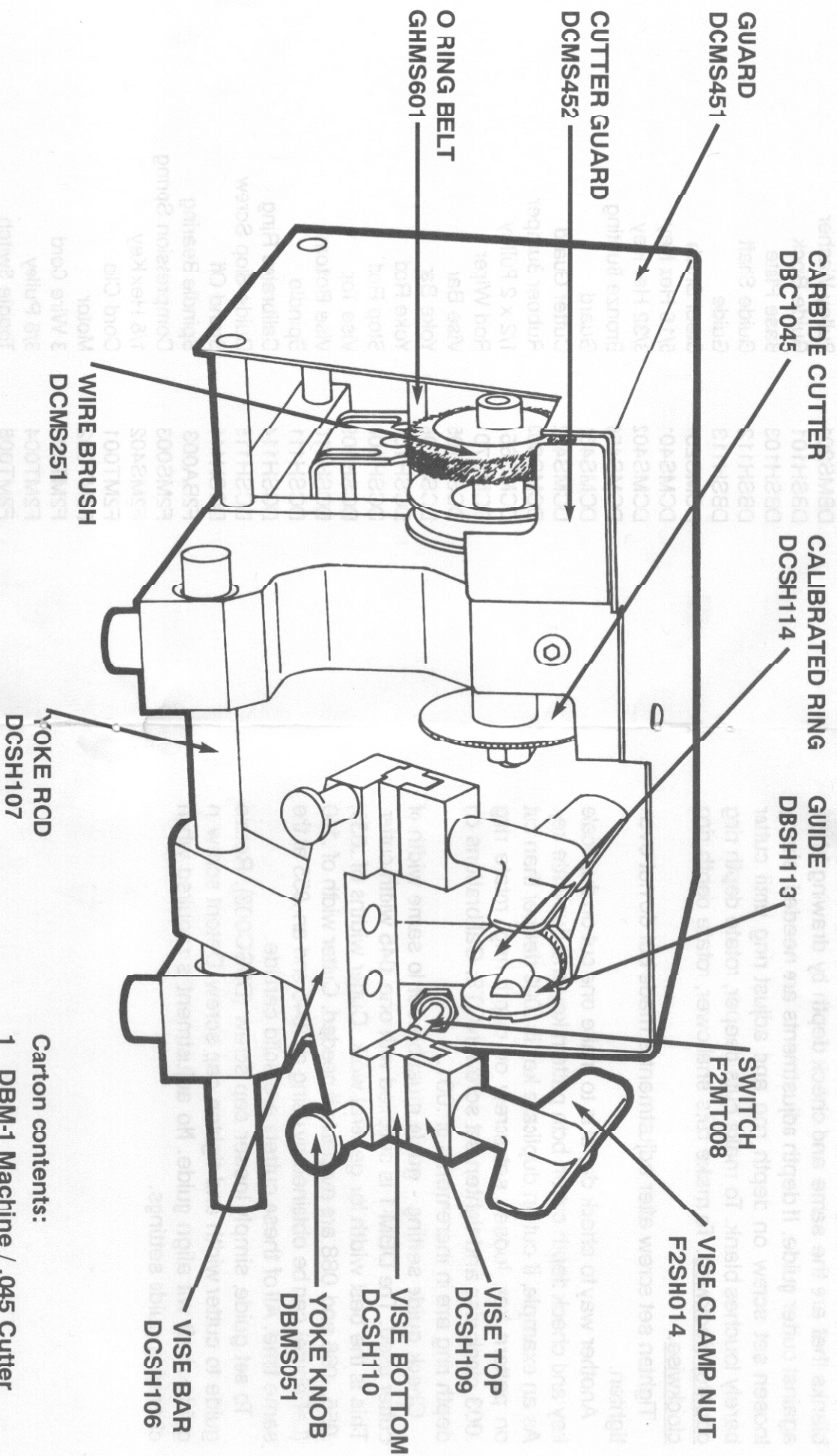
CAUTION: Cutter on the DBM-1 is solid carbide. Do not use excessive side pressure. There is always the possibility of breakage when side pressure is applied. Always use protective eyewear.

WARRANTEE

The warrantee on the Framon DBM-1 is in effect for a period of one year from date of purchase. Framon Mfg. Co. will replace all or any part of any machine proven to be defective as to material or workmanship. If any machine is returned to us in the first year, Framon Mfg. will absorb all cost for repairs, including freight. After one year, Framon Mfg. will charge customer for parts, a flat labor rate, and freight. Machines will be repaired and returned within two days of receipt. This warrantee is valid to the original purchaser only. Cutters are not converted by this warrantee. Framon cutters are among the finest cutters made today, but we have no control over their use.

WARRANTEE CLAIMS PROCEDURE

Purchaser must inform Framon Mfg. by telephone or letter and obtain permission from Framon before returning any machine. Framon will not accept any machine returned without prior permission. Any correspondence pertaining to any problem with a Framon machine should include date of purchase, from whom purchased and serial number of machine.



Carton contents:

- 1 DBM-1 Machine / .045 Cutter
- 1 3/32 Allen Wrench
- 1 5/32 Allen Wrench
- 1 1/8 Allen Wrench
- 1 5/16 Allen Wrench
- 1 Instruction and Parts Manual

ADJUSTMENTS

With tip setting for spacing there is no adjustment needed for spacing.

As to depth settings, this can be checked by using two blanks that are the same and check depth by drawing blank against cutter guide. If depth adjustments are needed, simply loosen set screw on depth ring and adjust ring until cutter barely touches blank. To make cuts deeper, rotate depth ring counterclockwise. To make cuts shallower, rotate depth ring clockwise.

Tighten set screw after adjustment is made but do not over-tighten.

Another way to check depth is to make one cut on duplicate key and check depth cut on both pattern key and duplicate key. As an example, if cut on duplicate key is .003 deeper than cut on pattern key, loosen set screw on depth ring, rotate ring .003 clockwise and tighten set screw. NOTE: Calibrations on depth ring are in increments of .001.

Check guide setting - guide must be set to same width of cutter used. The DBM-1 is supplied with one .045 width cutter. This is the best width for general work. Cutter widths of .035, .055, .066 and .088 are available if needed. Cutter width of .100 (LeFebure) can be obtained by using an .045 and an .055 at the same time. All of these cutters are solid carbide.

To set guide, simply loosen cap screw (DBSC003). Rotate guide to cutter width and tighten cap screw. Detent screw in guide shaft will align guide. No adjustment is required when changing guide settings.

PARTS LIST

DBC1045	Carbide Cutter
DBMS001	Spring
DBMS051	Yoke Knob
DBMS201	Pulley Washer
DBSH101	Guide Block
DBSH103	Base Plate
DBSH112	Guide Shaft
DBSH113	Guide
DCMS251	Steel Erush
DCMS401	5/16 Hex Key
DCMS402	3/32 Hex Key
DCMS450	Bronze Bunting
DCMS451	Guard
DCMS452	Cutter Guard
DCMS603	Rubber Bumper
DCMS651	1/2 x 2 Pulley
DCMS701	Rod Wiper
DCSH105	Vise Bar
DCSH106	Yoke Bar
DCSH107	Yoke Rod
DCSH108	Stop Rod
DCSH109	Vise Top
DCSH110	Vise Bottom
DCSH111	Spindle
DCSH114	Calibrated Ring
DCSH115	Guide Stop Screw
DCSH116	Stand Off
F2BA003	Spindle Bearing
F2MS003	Compression Spring
F2MS402	1/8 Hex Key
F2MT001	Cord Clip
F2MT002	Motor
F2MT003	3 Wire Cord
F2MT004	3/8 Pulley
F2MT008	Toggle Switch
F2MT009	On/Off Plate
F2SH014	Vise Clamp Nut
F2SH035	Spacing Washer
GHMS601	O Ring Belt